



Dart Aerospace Ltd.
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D3953-17
Job Sheet 195034



Part No: D3953-17

Job Qty: 24 pcs

Part Name: Gas Spring Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 7/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	24 pcs	7/15/19	7/15/19	0.00	2.40	Waterjet - Omax		du 19/07/05
110	QC 2	24 pcs	7/15/19	7/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		du 19/07/05
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

120	QC 8	24 pcs	7/15/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130	Small Fab - 2 - B4B	24 pcs	7/15/19	0.00 0.94	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
140	QC 5	24 pcs	7/15/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
150	Packaging 3-1 - Stock - B4B	24 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

DAS
40
JUL 09 2019
9-88

N/A

BE319-07-02

				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				160 QC 21 - SA	24 pcs	7/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 JUL 09 2019
								QC 21 - SA - 70	
								QC 21 - SA - 53	
				Part Op 100 - 1-Cut as per Dwg D3953 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Small Fab) 1- OPEN HOLES AS PER DWG 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: <i>F.Pooy</i>) 160 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				M304B0.375X03.000	M304 SS bar .375 x 3.00	.7500 ft (.03125 ea)	100-Waterjet - Omax - 1	<i>3172181</i>	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	M304B0.375X03.000	1	14	0					
Part Specifications									
Specifications could not be found.									

DART AEROSPACE LTD		Work Order:	195034
Description: Gas Spring Spacer		Part Number:	D3953-17
Inspection Dwg: D3953 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	Ø.193	1			
0.375	+/-0.010	.377	1			
0.625	+/-0.010	.623	1			
1.38	+/-0.030	1.382	1			
0.38	+/-0.030	.378	1			
0.75	+/-0.030	.758	1			
0.38	+/-0.030	.366	1			

Measured by:	<i>[Signature]</i>	Audited by:		Prototype Approval:	N/A
Date:	19/07/08	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	<i>[Signature]</i>



Container No: S196145



Part: D3953-17

Job No: 195034

Serial No/Batch: S196145

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 07/05/19